Work Order Monday, March 1			,	*11	458	31*			SW	P 20	dout	Page 1
Revision ID:	03595-200-3 Rubber Cushio		A	Accept	*1	1900	040	100)* s	Setup Sta		S1* S2*
Start Date: 3 Required Date: 3 Reference:	3/10/2014 3/14/2014	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item :	ID:					
	Process Plai	n:	Date: 14-3-30 Date:	Tooling: SPC (Y/N):			ate:		R	Run Star Sto	P	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	s	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3595	Rev	A										
*100 *100* Waterjet FLOW CNC Waterjet		FLOW WATER JET Memo 1-Cut as per Deburr if ne	Dwg D3595 Dwg Ŕev: cessary	0.00 0.00 Prog Rev:_	<u></u> ∕ ∕ 2-				91	Ø	14-	3-10
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00								
110 QC Quality Control	. *	Memo		0.00					_21_	A	14-3.	10
120 *1 20* QC	•	QC8- Inspect parts - seco	ond check	0.00 DAS 27 0.00 9 3	•				2/			
Quality Control					110							

Quality Control

DQA:			Date:											$T \mathbb{Q} \mathbb{A} \mathbb{G}^{Z}$
QA Closed:			Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / UF		ork Order up	ndate only	_	AEROSPACE
Q/ Closeu.			Dute.								•		1	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	•					Rework]		Skid-tube	Crosstube		Water Jet		Engineering
Part N	۱o. ₋					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	_	Other
NCR N	Ю.					Suspected Unapproved			Large Fab	Composite	<u> </u>	Supplier		
Root					Desc	ription of work order update		nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	١	QC Inspector
Design														*
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Handling/Pre														
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Operator														
Offset/Setup	_						Į							
Process	Ш													
Supplier	Ш													
Training														
Transport							Ì							
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Landi						General		1		<u></u>	Ta 80.		\neg	D
		Bending	- .		\vdash	Bend BOM/Boute	\vdash	1	Program	-	Outside Dim	ŀ	_	Pressure/Forced
		Centre No Cracks	ot Concer	itric	 	BOM/Route Broken/Damage/Defect	-	Grain Hardwa		 	Over/Under Part Incorred	t t		Set-up Temperature/Cure
	-		ak/Binnla	Mayo	-	-	-	4		aualified	┥	ŀ	-	Weld
	-	Crimp/Kir Cuffs	ıv vibbie	, wave	\vdash	Burrs	\vdash	1	ion Incomplete/Un ions Incomplete/U	_	Part Lost/Mi Part Moved	Silig		Wrong Stock Pulled
	_	Crushing				Contamination Countersink	\vdash	4	gned/off center	Inclear -	Positioned V	Vrong		wrong stock rulled
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	-	Inspectio		Tuhe	\vdash	Drawing	\vdash	Misrea		<u></u>	Ti owei rossi.	Juige [Otilei
	_	Marks/Ch	-	·ubc		Drill Holes		Off-set						
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						1		100001						

Work Order ID 1	14581
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114581

Page 2 Monday, March 10, 2014 4:01:59 PM **Item ID:** D3595-200-300 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Rubber Cushion **Start Date:** 3/10/2014 **Start Oty: 20.00** *20* **Cust Item ID: Required Date: 3/14/2014** Req'd Qty: 20.00 *20* **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Accept **Work Center ID Description Run Hours** Qty Code Qty Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *120* 5+4/2 Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 MLS 14-03-11 YWF M-3-22 *140* OC 0.00 Memo Quality Control

DQA:		Date:			•								7
					WORK ORDER NON-	-CC	ONFO	RMANCE / UF			_	AEROSPACE	!
QA Closed:		Date:							<u> </u>	Vork Order up	odate only		
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
					Rework	ì		Skid-tube	Crosstube		Water Jet	Engineering	
Part No	0.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is		l .	noforming	Finishing	_	re/Packaging	Other	
NCR N	o				Suspected Unapproved			Large Fab	Composite		Supplier		
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Root				Desc	ription of work order update	l l	Initial	Acti		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector	_
Design	4				•								
Doc/Data	4]					
Equip/Tooling													
Handling/Pre	_												
Material								:					
Operator	\dashv												
Offset/Setup	\dashv							·					
Process Supplier	-		1										
Training													
Transport	_												
Unapproved													
		•				FA	ULT CA	TEGORY					
Landin	g Gear				General						_		
	Bendir	ıg			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
\ \ \	Centre	Not Conce	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect	_	Hardwa	are		Part Incorre		Temperature/Cure	
<u> </u>	—	Kink/Ripple	e/Wave		Burrs	L	-1 -	ion Incomplete/Un	· -	Part Lost/M	issing	Weld	
]	Cuffs				Contamination	$ldsymbol{f eta}$	-	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled	
	Crushi	-			Countersink	L	-	gned/off center	-	Positioned V	P**	¬ .	
<u> </u>	Heat T			\vdash	Cut Too Short	\vdash	Mislab		L	Power Loss/	Surge [Other	
-		tion Strip in	Tube	_	Drawing	<u> </u>	Misrea						_
		/Chatter			Drill Holes	<u> </u>	Off-set						
<u> </u>	_	g Sequence		<u> </u>	Finish	_	-1	Calibration			· · · · · · · · · · · · · · · · · · ·		
	Wave/	Twist in Tul	be		Fit/Function	L.	Out of	Sequence					

Picklist Print

Monday, March 10, 2014 4:01:56 PM

Work Order ID: 114581

114581

Parent Item:

D3595-200-300

D3595-200-300

Parent Item Name: Rubber Cushion

Start Date: 3/10/2014

Required Date: 3/14/2014

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 08-05-14 DD Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO80S.125		Purchased	No	,	110	sf	740.9344	0.0206	1			

MNF080S 125

NEOPRENE SHEET 0.125

Location MAT052

115916

Loc Oty 740.9344

131.1044 609.83 Loc Code

**

A 14-3-10

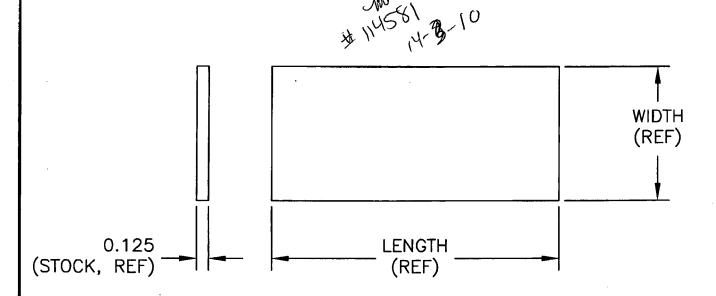
DQA:			Date:										•	$\mathcal{L}_{\mathcal{Q}}$
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	\Box	•
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	10.					Rework Scrap Use-as-is		Ĭ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	10.					Suspected Unapproved			Large Fab	Composite].	Supplier		
Root		. "			Desci	ription of work order update	П	Initial	Act	tion	Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator														
Offset/Setup														
Process Supplier														
Training														
Transport														
Unapproved							1							
· · · · · · · · · · · · · · · · · · ·						···	FAI	ULT CAT	regory					
Landi	ng (Gear				General								
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concen	itric		BOM/Route		Grain			Over/Under	tolerance	;	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ાં [r	Temperature/Cure
		Crimp/Kir	nk/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	\	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/l	Unclear	Part Moved		\Box	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong _		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge [(Other
		Inspection	n Strip in	Tube		Drawing		Misread	t					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S				Finish		Out of 0	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					



-	DESIG	PH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	¥
	CHEC	KED .//	APPROVED /	DRAWING NO.	REV. A
			1	D3595 SHEET	1 OF 1
	DATE		1	TITLE	SCALE
	07.0	02.07		RUBBER CUSHION	NTS
	Α		07.02.07	NEW ISSUE	

07.02.14 #

SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3595-XXX-YYY RUBBER CUSHION
WIDTH
LENGTH

EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

NOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DQA:			Date:			·							*	TRAGE
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		ork Order up	odate only	_	AEROSPACE
Work Orde	```					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	٠٠٠.					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root		D-4-	C1		Desci	ription of work order update	ì	Initial		tion	Sign &	., ., .,		
Cause	\dashv	Date	Step	Qty		or non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	1	QC Inspector
Design Doc/Data														
Equip/Tooling	Ш						1							
Handling/Pre	Н		-											
Material Operator	\vdash													
Offset/Setup	Н					•								
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Supplier	H												- 1	
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Transport														
Unapproved														
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		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	દાં [`	Temperature/Cure
	_	Crimp/Ki	nk/Ripple	/Wave		Burrs	<u></u>	Inspecti	on Incomplete/U	nqualified	Part Lost/Mi	ssing	\	Weld
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	ldash	Crushing				Countersink			ned/off center		Positioned V	· ·		
	Щ	Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge		Other
	_	Inspectio		Tube		Drawing		Misread	i					
		Marks/Ch				Drill Holes		Off-set						
1		Turning S	equence			Finish	L	Out of 0	Calibration					
 -		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of S	Sequence					-

DART AEROSPACE LTD	Work Order:	114 58 /
Description: Rubber Cushion	Part Number:	D3535-200-300
Inspection Dwg: D3595 Rev: M		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	H-0-030" 2-000 H-0-030 H-0-010"	2.00"	<u></u>		J	Stemoi
3.00"	4-3-000	3,00	·		7	
0.625	11-0.010"	OIT25"	-		V	
		·				
· · · · · · · · · · · · · · · · · · ·						
						
···						
		:				
			DAS			

	Measured by:	Im	Audited by:	9-89/	Preliminary Approval:				
-	Date:	14-03-11	Date:	14/3/11	Date:				

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15